

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019547**Date Inspected:** 27-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Yu Zhi Lai.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path, fit up end plate

PCMK: BK004A6-026

Weld No. 001,002,

Tack Welder: 057242

WPS-B-T-2312

Component; Tower

PCMK: ND1-BPSA5-1-1

Temporary attachments

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Tack Welder: 057269  
WPS-B-T-2212

Component; Tower  
PCMK: ND1-BPSA5-1-2  
Temporary attachment  
Tack Welder: 057269  
WPS-B-T-2212

Component; Tower  
PCMK: ND1-BPSA5-2-1  
Temporary attachment  
Tack Welder: 057269  
WPS-B-T-2212

Component; Tower  
PCMK: ND1-BPSA5-2-2  
Temporary attachment  
Tack Welder: 057269  
WPS-B-T-2212

Heat straightening of PCMK, Lift 13 SP3083A-001 under approved Heat Straightening procedure, HSR1(B)-9858. The in process temperature was observed as 230°C. The ZPMC QC was identified as Yu Zhi Lai. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 20mm.

In front of blast shop 1

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member(s) are identified as SEG3003G,E,C, and J. The weld designations reviewed are as follows: SEG3003G-020~159, SEG3003E-020~156, SEG3003C-020~146, SEG3003J-020,022,024,026,028,030,032,034, 036, 038,040,042,044,046,048,050,052,054,056,058,060,062,064,066,068,070,072,074,076,078,080,082,084,086, 088,090,092,094,096,098,100,102,104,106,108,110,112,114,116,118,120,122,124,126,128,130,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Leavitt,Kelly	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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